

Date: Thursday, 9/20/2007 3:29:16 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RING
Job Number : 34752	
Estimate Number : 10608	
P.O. Number : <u>N/A</u>	Part Number : D2655
This Issue : 9/20/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2655 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 34613	Material : <u>N/A</u>
Written By : <u>JA 07-09-20</u>	Due Date : 9/27/2007 Qty: <u>50</u> Um: Each
Checked & Approved By : <u>JA 07-09-20</u>	
Comment : Est. D 00-06-22 Removed P/O for powder coat EC	
Est Rev:E Now on Waterjet 06-10-04 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1018B400X250	Inventory
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Comment: Qty.: 0.2835 f(s)/Unit Total : 8.5050 f(s)

1018 ASTM A36 .250" thk bar x 4.0"

Batch: M105670 9X

LB 07-09-27

M105358 5X

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2655

Dwg Rev: B

Prog Rev: B

LB 07-09-27

50

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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LB 07-09-27

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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center

Comment: SECOND CHECK

LB 07-09-27 50

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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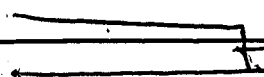


Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius

2-Deburr any rough edges after tumbling

3-open holes 10.25"



LB 07-10-09

50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/12

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 34752

Part Number: D2655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

5 07/10/09 450

7.0

POWDER COATING

POWDER COATING



50X

Comment: POWDER COATING

Powder Coat per QSI 005 4.3.5.1

m-l 07/10/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-11

50

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

507/10/11 50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



50

Comment: FINAL INSPECTION/W/O RELEASE

2010/10

Job Completion



Li 07.10.12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

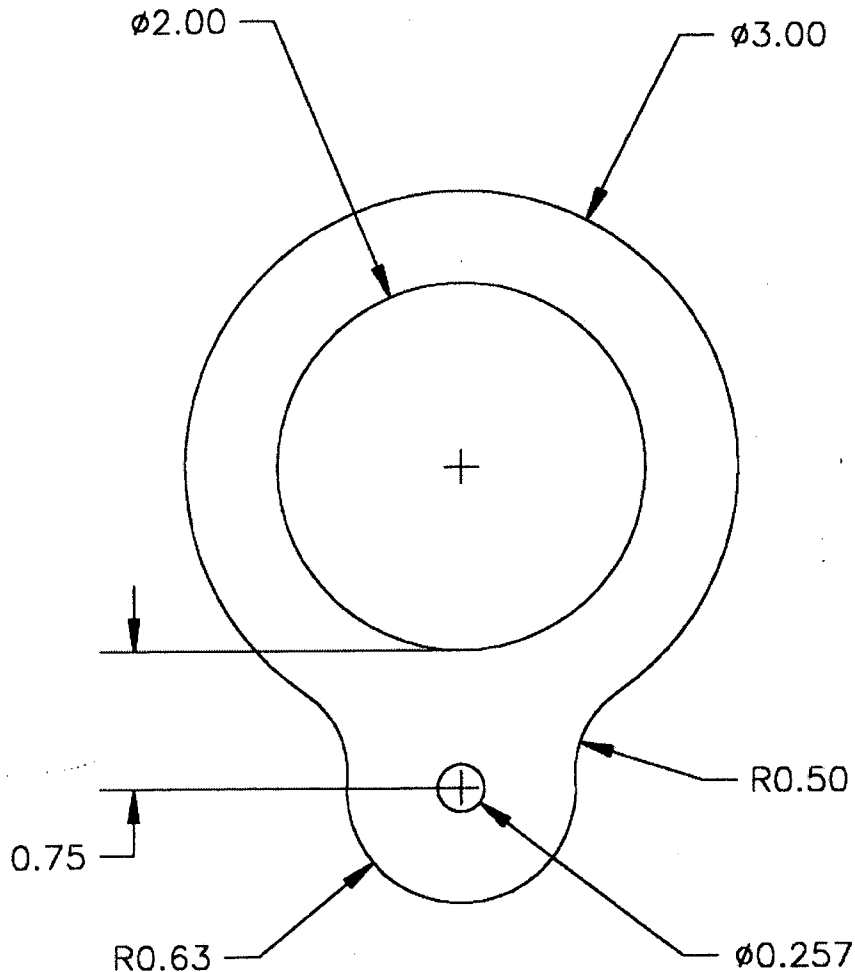
NOTE: Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING	SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

RELEASED  
47/07/11 DS



NOTE: DEBURR ALL SHARP EDGES  
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK  
FINISH: POWDER COAT PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 34752

